

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.22P.A**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000298**Date Inspected:** 07-Jun-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Shanghai, China**Witness:** **Procedure Qualification Record**
Welding **NDT****Welder Qualification** **Fracture Critical**
Mechanical Testing, describe:**Index Lot #:** B72-037-07**Witness Lot #:** B26-011-07**Bridge No:** 34-0006**Component:** Bid: 52,55 Tower & Girder**Welder:** Zhu Hai Ping**ID #:** N/A**Joint Description:** B-U2a

N/A

WPS ID #: PWPS-B-T-3214

N/A

Base Metal: A709M-HPS-485W

N/A

PQR ID #: HP200778-1

N/A

Thickness: 25 millimeters

N/A

Process: SMAW

N/A

Electrode Spec/Class: AWS A5.5/ E9018M MR

N/A

Positions: Overhead 4G

N/A

Backing Material: A709M-HPS-485W

N/A

CWI: Wei Huang

N/A

Average Amps:

N/A

AWS Code: AWS D1.5 2002

N/A

Average Volts:

N/A

Applicable Sec: Paragraph 5.13

N/A

Travel Speed:

N/A

Heat Input:

N/A

Preheat:

N/A

Summary of Items Observed:

1) PQR Test Plate HP200778-1- The Caltrans QA Inspector observed that the presented radiographs for this PQR test plate contain linear indications that are not in compliance with the requirements of AWS D1.5 (2002). It is inconclusive as to whether or not the PQR test plate weld cap with multiple weld passes represents the linear indications within the radiographs. The Caltrans QA Inspector and ZPMC representative Mr. Lu Jian Hua visually observed that the PQR test plate weld cap has been partially ground flush prior to radiographic testing. Mr. Lu Jian Hua stated that the weld cap needed to be completely ground and subsequently radiographically tested again. Radiographic film reviewers for ZPMC and ABF representative Mr. Nate Lindell did not address this issue prior to this review by the Caltrans QA Inspector. Within the Caltrans 6031 for this date the Caltrans QA Inspector captured by digital picture the PQR test plate which contains a partially ground weld cap and also a digital picture of a ZPMC welder grinding the weld cap of the PQR test plate after the Caltrans QA Inspector and Mr. Lu Jian Hua observed that the weld cap was only partially ground.

This 6032 is supported with a Caltrans 6031 for this date.

Summary of Conversations:

As identified within the contents of this report.

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is in general conformance with the contract requirements.

Observed welding,testing or results:

is not in conformance with the contract requirements.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Cuellar,Robert

Quality Assurance Inspector

Reviewed By: McClary,David

QA Reviewer